

ALPHA[®] DEOXIDIZATION TABLETS P3

DESCRIPTION

The Alpha solders VACULOY[®] Ultra Low Lead (ULL) SAC305 and SAC405 were developed specifically for the lead-free soldering process on printed circuits in wave soldering systems. Owing to the protected ALPHA VACULOY alloying process, these alloys particularly exhibit a low oxidization rate and drossing.

However, lead-free soldering is enjoying growing demand, especially at higher process temperatures (dip soldering), so Alpha is offering its **ALPHA Deoxidization Tablets P3** for the lead-free soldering process, specifically for suppressing the tendency to oxidize and reduce drossing.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

PRODUCT INFORMATION

Alloy: L-Sn97 with Anti-oxidization Additive
Melting Range: 230 to 232 °C

The additive should be 40 to 80 ppm of the lead-free soldering bath. This serves to lower the solder's surface tension for less drossing and reduced stringing and bridging.

On the surface of the melted solder, the anti-oxidization additive promotes the formation of a colorless, passivating and invisible film that protects the melt at temperatures of 225 to 300 °C from further oxidization.

APPLICATION GUIDELINES

Basic Lead-Free Soldering: The basic configuration of the lead-free soldering bath consists of 150g of ALPHA Deoxidization Tablets P3 in 100kg of bath solder.

Flow & Drag Soldering: The anti-oxidization content in flow and drag soldering systems is replenished with the addition of 5 to 7 ALPHA Deoxidization Tablets P3 per 10kg of bath content.

Dip Soldering: The anti-oxidization content in dip soldering systems (general tinning work) is replenished with the addition of 2 to 4 ALPHA Deoxidization Tablets P3 per kg of bath content.

Anti-Oxidization Content Verification: The correct anti-oxidization content in the solder is verified with the so-called tarnishing test. The solder is heated to 350 °C and the first oxide film is removed. At the end of about one minute, the solder may not exhibit any tarnishing.

AVAILABILITY

ALPHA Deoxidization Tablets P3 are packaged in a 1kg unit of 250g boxes.

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams. Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at MacdermidAlpha.com/assembly-solutions/knowledge-base.**

CONTACT INFORMATION

To confirm this document is the most recent version, please contact
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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